

Work Order ID 53692

November 12, 2009 3:59:48 PM



Page 1

Item ID: D212-664-101

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Fwd

Start Date: 11/12/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/09 Req'd Qty: 1.00



Customer:

Reference: Return 2009 / RA109111

Approvals: Process Plan: Ux Date: _____ Tooling: _____ Date: _____

Run Start



QC: 09-11-12 SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-664-141	Rev C

100 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

Original B47753 @ CHG003.
Kit complete & good condition.

110 Identify as per dwg & Stock Location: _____ 0.00



Packaging

Memo

0.00

Packaging

New labels require with the new batch # @ CHG003.
Clean & return to stock.

130 QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D212-664-101	CHG	CHG003		
DESC.	Crosstube Fwd High	STC	SH01-9		
LOT	B47753	STC	SR01298NY		
MODEL	Bell 204/205/210/212/412/UH-1	STC			
MADE IN CANADA					

1 09-11-12

09-11-13
09/11/16

09/11/17

09-11-16

Date: Tuesday, 05/05/2009 3:37:55 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH FED X-TUBE ASSEMBLY
Job Number	: 47753		
Estimate Number	: 10254		
P.O. Number	:	Part Number	: D212664101
This Issue	: 05/05/2009 S.O. No. :	Drawing Number	: D212-664-141 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : CROSSTUBES	Drawing Revision	: C
Previous Run	: 47752	Material	:
Written By	:	Due Date	: 25/05/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>Julie Dawson</u>		
Comment	Est Rev:E 04.02.16 Reformat KJ/DS Est Rev:F 06-03-29 Remove Comments on Pick List JLM Est Rev:G 07-04-30 As per Rev C JLM		

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101 (CHG003)

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D212664101TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch 8-47267

4.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

Date: Tuesday, 05/05/2009 3:37:55 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 47753

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2- Install supports with magnobond as per QSI 015 Adhere for 12 Hrs

A/R 6398 Magnobond

Batch: 111249

Expiry Date: 02/2010

3- Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

ml 09.05.12 (1)

ml 09.05.13 (1)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.05.13 (1)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

20.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLACARD

Batch: 1345182

1342448

9/5/13

sq

21.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109282

9/5/13

sq

22.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M110382

9/5/13

sq

Date: Tuesday, 05/05/2009 3:37:55 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 47753

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD616

Washer



9/5/13



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M1111193

SP

24.0

MS21042L6

Nut



9/5/13



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M110002

SP

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

809/05/14

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

9/5/14

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/14

Job Completion



mf
09-05-14

B47753 D212-664-101